1

Date: User: Wednesday, 12/11/2008 1:32:04 PM

Julie Dawson

Process Sheet

Customer

Prsht Rev.

First Issue

Written By

Previous Run

: CU-DAR001 Dart Helicopters Services

S.O. No. :

: 43347

Job Number : 12825 **Estimate Number**

P.O. Number

This Issue

: 12/11/2008

: NC

: 11

: 42821

: SMALL /MED FAB Type

Drawing Number Project Number

Drawing Revision

Drawing Name

Part Number

Material

Due Date : 21/11/2008

: DOUBLER

: D3578041

: N/A

: A

: D3578 REVA

Qty:

40 Um:

Each

Checked & Approved By

Comment

: Est: A 07.04.11

New issue EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M6061T6S080

6061-T6 .080 Sheet

Comment: Qty.:

0.0074 sf(s)/Unit

6061-T6 sheet 0.080"

(M6061T6S080)

Total:

0.2940 sf(s)

2.0

Batch: WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3578 (Run prog. D3578-1)

Dwg Rev:_ Prog Rev:_

B 8-11-17



2-Deburr if necessary

3.0

QC2

图 8-11-17

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8 4.0

SECOND CHECK



Comment: SECOND CHECK



5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open rivet holes to 0.098" and C'sink as per dwg D3578



Page 1

Form: rprocess

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vV/O:			WC	RK ORDER CHANG	GES			-		<u>.</u> .
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:			
Part No):	PAR #:	Fault Cate	gory:	NCF	: Yes I	No DQA		_ Date: _	
		esolution:								
NCR:	•		WORK ORD	ER NON-CONFORM	IANCE	(NCR))			
DATE	STEP	Description of NC			ction B		Verifica	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Section		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

7	dnesday, 12/11/2008 1:32:04 PM e Dawson	Process Sheet	
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: DOUBLER	
Job Number:	43347	Part Number: D3578041	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
6.0	QC5	INSPECT WORK TO CURRENT STEP COUNTY OSUM 18	
7.0	ent: INSPECT WORK TO CURRENT STEP HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comme	ent: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 00	054.1 Hl 08-11-19 X75	
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 750	
	ent: INSPECT POWDER COAT/CHEMICAL		
9.0	MS21075L3	Nutplate	
Comme	Nutplate Batch: 14109063	40.0000 Each(s) 80 08 1119 7	5
10.0	MS20426AD33	Rivet	
Comme	ent: Qty.: 2.0000 Each(s)/Unit Total : Rivet $4 \$	80.0000 Each(s) So 8 111 19 7	5
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comme	ent: SMALL & MEDIUM FAB RESOURCE 1 1-Assemble as per dwg D3578	ED08/11/19 (75)	
12.0	QC5	INSPECT WORK TO CURRENT STEP	
	ent: INSPECT WORK TO CURRENT STEP	J DE (4/20 (475)	
13.0	PÄCKAGING 1	PACKAGING RESOURCE #1	
Comme	ent: PACKAGING RESOURCE #1 Identify and Stock Location: SA 344 A	(= S/4/20 (75)	

Page 2

Form: rprocess

Dart Aerospace Ltd

	have									
W/O:			, W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cat	tegory:	_ NCR:	Yes N	lo DQ	A:	_ Date: _	
	R	esolution:	Disposit	on:	_ QA: N	I/C Clos	sed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE ((NCR)				
DATE	STEP	Description of NC			ion B	0:	Verific	ation	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date: User: Wednesday, 12/11/2008 1:32:04 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43347

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

QC21

FINAL INSPECTION/W/O RELEASE

08/11/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-2

Dart Aerospace Ltd

									
W/O:			WC	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			· · · · · · · · · · · · · · · · · · ·						
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	n:	QA: N/C CI	osed:		Date: _	
NCR:		\	WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Work Order: 스 DART AEROSPACE LTD D3578-1 Part Number: **Description:** Doubler Inspection Dwg: D3578 Page 1 of 1 Rev: A

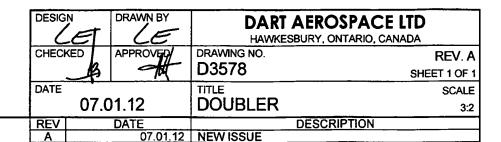
FIRST ARTICLE INSPECTION CHECKLIST

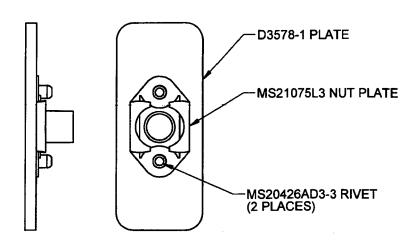
		X First A	rticle	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
Ø0.098	+0.004/-0.001	101	Æ				
Ø0.203	+0.005/-0.001	1306	ملا				
0.63	+/-0.030	:631	X				
1.50	+/-0.030	4491506	X				
0.500	+/-0.010	.500	æ				
0.250	+/-0.010	176,	X				
0.50	+/-0.030	#1,5B	X				
0.313	+/-0.010	,33	×				
		1 [$\overline{}$				N1/A
Measured by:	₩	Audited by	/: \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\		Prototype App	roval:	N/A

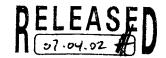
Measured by:	Audited by:		Prototype Approval:	N/A
Date: 8-11-	Date: 3	shilz	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	07.11.23	New Issue	P/O D3578-041	KJ/EC/DD	7







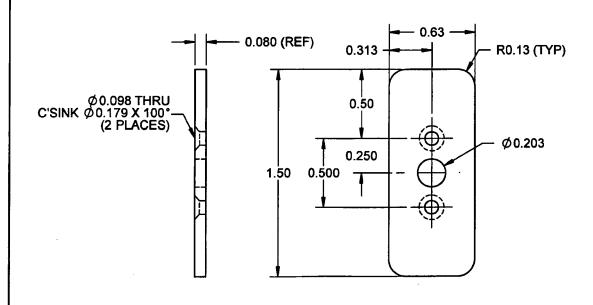


D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER

<u>D3578-041 NOTES:</u>
1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER





SUBJECT TO AMENDMENT WITHOUT NOTICE

D3578-1 PLATE

D3578-1 NOTES 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 NEERING (REF DART SPEC M6061T6S.080)

UNCONTROLLED UNCONTROLLED COPY

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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